

Work Order ID 58215

Thursday, April 29, 2010 10:38:28 AM



Page 1

Item ID: D3536-39

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 4/29/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-4-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessaryB10-S-11(12)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B10-S-11

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

S w l 3 / 12(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Item Name: Gasket

Start Date: 4/29/2010 Start Qty: 8.00

Required Date: 5/14/2010 Req'd Qty: 8.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: *FPD*

0.00

Memo

0.00

10-5-12

(12) SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/13

PS 10-5-12

(12)

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Picklist Print

Thursday, April 29, 2010 10:38:28 AM

Page 1

Work Order ID: 58215

Parent Item: D3536-39

Parent Item Name: Gasket

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Date: 4/29/2010

Required Date: 5/14/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	208.7531	0.7534			
NEOPRENE SHEET 0.063												

Location

MAT052

114176

Loc Qty

208.7531

208.7531

Loc Code

114176

114176 B10-5-11

(12)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58215
Description: Gasket		Part Number:	D3536-39
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.71	✓			
32.78	+/-0.030	32.78	✓			
29.28	+/-0.030	29.28	✓			
25.78	+/-0.030	25.78	✓			
23.25	+/-0.030	23.25	✓			
19.75	+/-0.030	19.75	✓			
17.75	+/-0.030	17.75	✓			
14.25	+/-0.030	14.25	✓			
9.50	+/-0.030	9.50	✓			
4.75	+/-0.030	4.75	✓			
5.00	+/-0.030	5.00	✓			
9.00	+/-0.030	9.00	✓			
0.30	+/-0.030	-305	✗			
0.30	+/-0.030	.305	✓			
1.88	+/-0.030	1.883	✓			
Ø0.19	+0.005/-0.001	.190	✓			
0.063	+/-0.010	.065	✓			

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A	
Date: <u>10-5-11</u>	Date: <u>10/5/12</u>	Date:	N/A	
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	<u>[Signature]</u>

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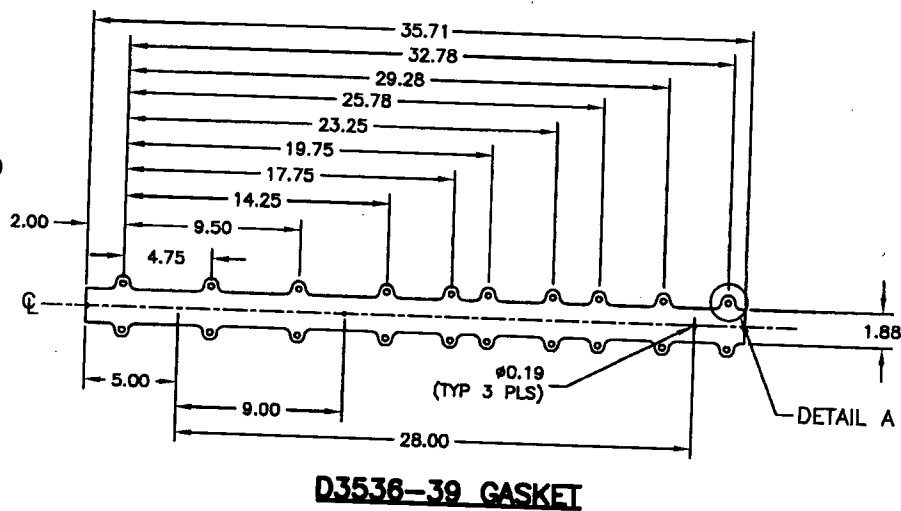
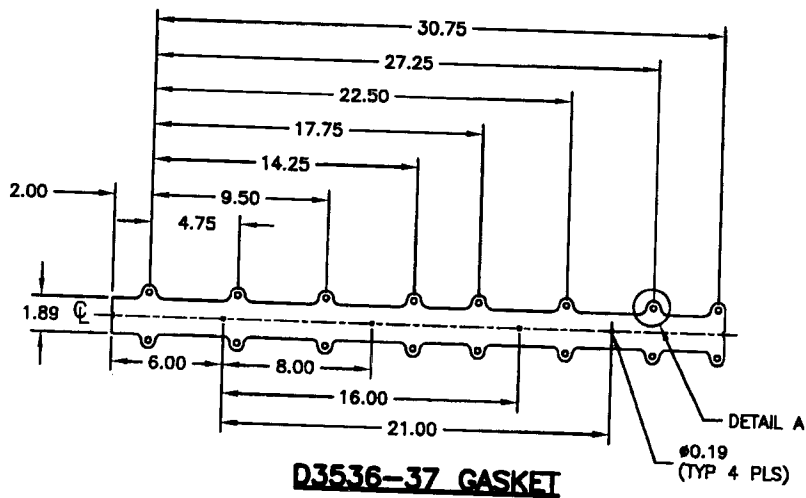
NOTE: Date & initial all entries

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
				SCALE 1:10

07.02.02
#

58215



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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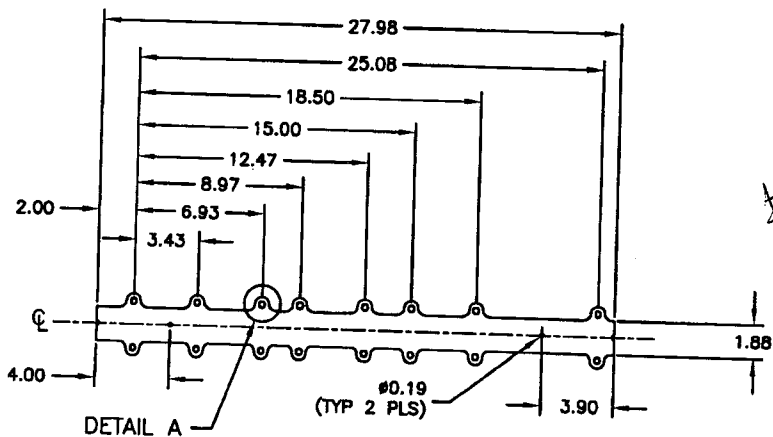
NOTE: Date & initial all entries

DART

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 6 OF 6
				SCALE
				1:10

07.02.12 CB

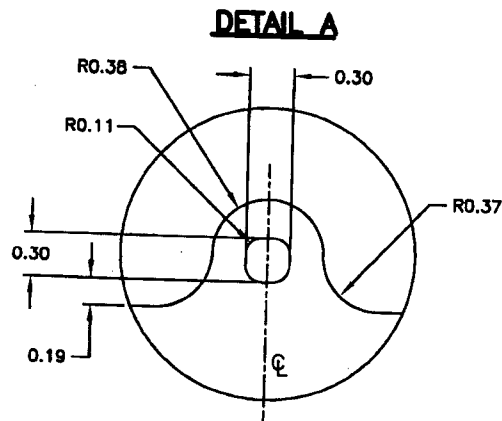
#58215



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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